

Work Order ID 158096

Thursday, March 09, 2017 1:59:39 PM

158096

Page 1

Item ID: D3019-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Cushion

Start Date: 3/13/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/27/2017 Req'd Qty: 2.00

2

Customer:

Reference: SCHEDULED

Approvals: Process Plan:

DAS
21
9-89

Date: MAR 10 2017 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3019

B

0.00

100

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O:

35615

Possible supplier: Chestnut Ridge Airflex fire-resistant aircraft cushioning

Order: Grade 30-40 (colour green), Density 2.6lb/ft³

Material must meet FAR 27.853(a) or 25.853(a), Part is symmetric about centerline

0.00

2

MAR 16 2017

DAS
13
9-89

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure Material Release Note is attached

0.00

0.01

2x SP17-03-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 158096

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158096

Page 2

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Accept

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Item Name: Back Cushion

Start Date: 3/13/2017 Start Qty: 2.00

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Cust Item ID:

Required Date: 3/27/2017 Req'd Qty: 2.00

2

Customer:

Reference: SCHEDULED

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

0.00

*****REMOVE "CHESTNUT FOAM" LABEL AND ATTACH TO WORK
ORDER FOR TRACEABILITY*****DAS
38
9-89
MAR 30 2017

130

Identify as per dwg & Stock Location: ST415

0.00

130

Packaging

Packaging

Memo

0.00

DAS
6
9-89DAS
41
9-89
MAR 31 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.03

17/4/4

DAS
21
9-89

APR 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, March 09, 2017 1:59:43 PM

Page 1

Work Order ID: 158096

158096

Parent Item: D3019-1

D3019-1

Parent Item Name: Back Cushion

Start Date: 3/13/2017

Required Date: 3/27/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B01.06.07Removed acid etch & alodine EC/SM
11.08.08 added note per NCR 11-588 DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3019-1P		Purchased	No			110	Each	0.0000	1	2			
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D3019-1P

Back Cushion

**

2x SP 17-03-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

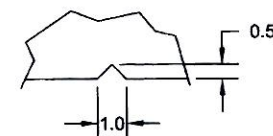
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

SPECIFICATION CONTROL DRAWING

TABLE 1					
THICKNESS/ HEIGHT	TOLERANCE		LENGTH/ DEPTH	TOLERANCE	
	(+)	(-)		(+)	(-)
0.0 - 0.50	0.06	0.06	0.00 - 6.00	0.06	0.06
0.51 - 1.00	0.13	0.06	6.01 - 12.00	0.13	0.13
1.01 - 3.00	0.13	0.06	12.01 - 24.00	0.25	0.25
3.01 +	0.19	0.13	24.01 +	0.50	0.38

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158096 MJS
17-03-10



VIEW A-A D7-1

RELEASED
2011-05-13

D3019-1 BACK CUSHION

NOTES:

- 1) MATERIAL: MUST MEET FAR 27.853(a) OR 25.853(a)
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING
GRADE 30-40 (COLOUR GREEN)
DENSITY 2.6 lb/ft³
- 2) FINISH: NONE
- 3) TOLERANCES: PER TABLE 1
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: TAG(S), BURNED, TO SHOW THE FOLLOWING AT MINIMUM:

CHESTNUT RIDGE FOAM, INC.
443 WAREHOUSE DR.
LATROBE, PA 15650
SO#
DATE MFD:
DART AEROSPACE LTD. P/N D3019-1

- 7) PART IS SYMMETRICAL ABOUT CENTERLINE
- 8) MAKE PER TEMPLATE
- 9) POSSIBLE SUPPLIER: CHESTNUT RIDGE P/N 601988-99

B	UPDATE TO CURRENT STD: DRAWING REVISED IAW CHESTNUT RIDGE MFG DWG. REF: NCR11-588	MB	11.05.10
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3019 SHEET 1 OF 1
TITLE SCALE
BACK CUSHION NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**Purchase Order ID PO35615**

Purchase Order Date 3/16/2017 10:19:13 AM
PO Print Date 3/16/2017

Page Number 1 of 2

Order From :

VU-CHE001

Ship To : DART AEROSPACE LTD

CHESTNUT RIDGE FOAM, INC.
PO BOX 6015
HERMITAGE, PA 16148
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

MAR 16 2017

Contact Name

Buyer

Chantal Lavoie

Vendor Phone 724 537 9000

Customer POID

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

USD

Ship Via: FedEx Overnight collect

FOB

Destination-Collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
2	D3019-1P AS PER DWG D3019 REV. B B158096	Back Cushion	3/27/2017 Yes 3/27/2017		2.00 Each	\$46.77	\$93.54
						Line Total:	\$93.54
3	71401-45	PROCUREMENT QUALITY CLAUSES	3/27/2017 No 3/27/2017		1.00	\$0.00	\$0.00
Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A026 certification of material conformance A027 flammability test A040 notification of quality escape A042 dart notification by supplier A043 retention of quality document							

Note:

3/16/2017

Chestnut Ridge Foam, Inc.
443 Warehouse Drive
P.O. Box 781
Latrobe PA 15650

Phone: 724-537-9000
Fax: 724-537-9003



Pack Slip: 69907

Packing Slip

Page: 1 of 1

Ship To: Fed Exp #1517-9324-0
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ON K6A 1K7
Canada

Phone: 613-632-3336
Fax: 613-632-1053

Sold To: Chantal Lavoie Fax#: 613-632-1053
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ON K6A 1K7
Canada

Phone: 613-632-3336
Fax: 613-632-1053

Ship Date: 3/28/2017

F.O.B.: Origin

Ship Via: Fed Exp P1

PO Line	Part Number/Description Planned Qty	Shipped Qty	Rev PO Line
---------	--	-------------	----------------

Sales Order: 57560

Your PO: PO35615

Salesperson: Matt Gurgio

Certificate of Conformity that all components comply with 14CFR 25.853(a) 12 Second Vertical Burn with Shipment
The following Quality Clause Codes apply to this order: A004, A005, A016, A026, A027, A040, A042, and A043.

Line 1

Rel 1

D3019-1P

AIRFLEX Back Cushion
2.00 EA

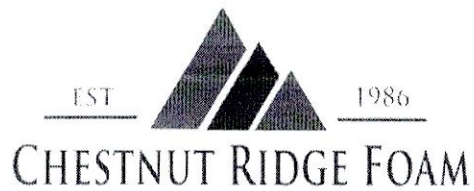
2.00 EA

Our Part: 601988-99

CONTACT CHESTNUT RIDGE FOAM IF THERE IS DAMAGE OR DISCREPANCIES 724-537-9000

SP17-03-29

DAS
38
9-88



"URGENT! FLAMMABILITY CERTIFICATE
ENCLOSED. PLEASE FORWARD TO
PURCHASING. DO NOT THROW AWAY!"

Certificate of Conformance

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury
Ontario CANADA K6A 1K7

PURCHASE ORDER: PO35615

SALES ORDER: 57560

DATE SHIPPED: 3/28/17

I certify that the individual components comprising the part(s) shipped against the above-referenced purchase order meets:

14 CFR 25.853(a), APPENDIX F, PART 1(a)(1)(ii), AMENDMENT 25-116

Quantity	Customer Part Number	CRF Part Number	Material	Batch Number
2	D3019-1P	601988-99	CR AIRFLEX 30-40	AF17010

MADE IN THE U.S.A

Kim Bohatch

*Digitally signed by Kim Bohatch
DN: cn=Kim Bohatch,
email=kbohatch@crf.lan, o=Chestnut Ridge
Foam, Inc., l=Latrobe, Pennsylvania
Date: 2017.03.28 11:47:48 -0400*

❖ 443 Warehouse Drive Latrobe, PA 15650
❖ Phone: 724-537-9000 Fax: 724-537-9003

CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 16389
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : CR AIRFLEX
BATCH / LOT NO : AF17010
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : CR AIRFLEX 30-40, 1/2 inch thickness
CRF P/N:

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : GREEN

CONDITIONING STARTED : DATE : 3-15-17
TIME : 9:00 AM

TEST STARTED : DATE : 3-16-17
TIME : 11:05 AM

RESULTS :

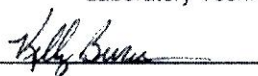
	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	3.2
#2.	0.0	0.0	3.4
#3.	0.0	0.0	3.6
AVG.	0.0	0.0	3.4

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F. PART 1, (a), (1), (ii).

TESTED BY : Kelly Bures
Laboratory Technician



PRODUCT TICKING FR 4440 FABRIC
BATCH/LOT NO 2308
CUSTOMER PRODUCTION
P.O. NO 36239
OTHER IDENTIFICATION

MELTS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550 F YES

MATERIAL PATTERN WOVEN

MATERIAL COLOR TAN

CONDITIONING STARTED DATE: 9-27-16
TIME: 11:30 AM

TEST STARTED DATE 9-29-16
TIME 10 25 AM

	FLAME TIME (SECONDS)		DRIPPINGS (SECONDS)		BURN LENGTH (INCHES)	
	WARP	FILL	WARP	FILL	WARP	FILL
#1	00	00	00	00	4.3	4.1
#2	00	00	00	00	4.3	4.3
#3	00	00	00	00	4.1	4.3
AVG	00	00	00	00	4.2	4.2

PASS : X FAR

COMMENTS

THIS MATERIAL MEETS THE REQUIREMENTS OF THE NCIK PART 25, SECTION 25.853, PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (3) (b)

TESTED BY: Kelly Bures
Laboratory Technician

HANES
-engineered materials-
a Lygell & Platt COMPANY

PLEASE PRINT TO:
HANE'S ENGINEERED MATERIALS
L&P FINANCIAL SERVICES CO
P O BOX 60984
CHARLOTTE, NC 28260

SHIP TO
CHESTNUT RIDGE FOAM
443 WAREHOUSE DRIVE
LA TROBE, PA 15650

INVOICE NUMBER		INVOICE DATE		TERMS		COUNTRY		BILLING		PRINCIPAL	
62-176765		9/23/2016		NET 30		USF HOLLAND INC		PER ANNETTE 8/21/14		C	
CUSTOMER PO#		CUSTOMER PO#		COUNTRY		INVOICE DATE		QUANTITY		PRICE	
15985		36239		65 452		9/20/2016		CONOVER, NC		DAY8	
PRODUCT		WIDTH		DIA#		DESCRIPTION		PUTUP		PRICE	
10 334		40 334		TICKING		PR 4440		250 RL CC 27			

VERIFICATION:

THE ABOVE DATA NOT ACCURATE, EITHER IMPLICITLY OR EXPLICITLY, THESE PRODUCTS TO MEET THE REQUIREMENTS OF ANY REGULATORY AGENCY OR SPECIFICATION EXCEPT AS MAY BE IDENTIFIED ABOVE OR UNDER SEPARATE WRITTEN CERTIFICATION. ALL TRANSACTIONS ARE SUBJECT TO THE CONDITIONS ON THE REVERSE SIDE OF THIS INVOICE.

USF HOLLAND INC PR# 10135783066

101 04 2016

15485

ORIGINAL

TOTAL INVOICE

PAGE 1 LAST 42874

CHESTNUT RIDGE FOAM, INC.

443 WAREHOUSE DR.
LATROBE, PA 15650

P/N: 601988-99

SO# : **57560**

DATE MFD: **03/17**



CHESTNUT RIDGE FOAM, INC.

443 WAREHOUSE DR.
LATROBE, PA 15650

P/N: 601988-99

SO# : **57560**

DATE MFD: **03/17**

